

CLAIMS

1. A plant for moulding and curing elongated concrete products which includes
 - a) at least one vertical mould
 - 5 b) support means above the mould to suspend the reinforcing material in the mould
 - c) pump means to fill the mould with concrete so that the elongated product forms around the reinforcing material
 - d) a vertical curing carousel adapted to vertically suspend the moulded elongated product
 - 10 e) a lifting apparatus adapted to lift reinforcing material into the vertical mould, to remove the formed product from the mould, to place it on the curing carousel and to remove it from the carousel when the product is sufficiently cured for storage.
- 15 2. A plant as claimed in claim 1 in which two moulds are used and the a lifting apparatus is positioned between the two moulds and a curing carousel is located adjacent each mould.
- 20 3. A plant as claimed in claim 1 or 2 in which the curing carousel has a sufficient number of product suspension points to enable a product to cure by the time the carousel has rotated at least 360°.
- 25 4. A plant as claimed in claim 1 in which the reinforcing mesh is suspended in the mould from at least two attachment points and a flexible link is used to attach the reinforcing mesh to the attachment points to reduce the likelihood of relevant movement between the reinforcing and the moulded concrete during removal and transfer from the mould.
- 30 5. A plant as claimed in claim 4 in which a support ring with at least two flexible chains hang from two equidistant points on the ring is used as the flexible link with the chains being attached to the reinforcing cage.

6. A plant as claimed in any preceding claim in which a lifting truss is used that is pivoted at one end adjacent the vertical mould so that reinforcing cages can be attached the truss in its horizontal position and raised to the vertical for insertion into the mould and moulded products can be lowered from the vertical to the horizontal position by the truss so that they can be transported in the horizontal position.
7. A method of forming elongated concrete products in which
- a) the products are formed in a vertical mould
 - b) the products incorporate a reinforcing mesh a portion of which extends from the top of the mould
 - c) the reinforcing mesh is suspended in the mould from at least two attachment points
 - d) a flexible link is used to attach the reinforcing mesh to the attachment points to reduce the likelihood of relevant movement between the reinforcing and the moulded concrete during removal and transfer from the mould.
8. A method as claimed in claim 6 in which the attachment means is used to suspend the moulded product when it is removed from the mould and placed in a vertical curing station.
9. A method as claimed in claim 6 or 7 in which the reinforcing cage is raised from the horizontal to the vertical using a truss pivoted at a point adjacent the bottom of the mould and the truss is also used to lower the moulded product from the vertical to a horizontal position for transport.